

HiFill® ABS 1512 3DP

Techmer Polymer Modifiers - *Acrylonitrile Butadiene Styrene*

General Information

Product Description

HiFill® ABS 1512 3DP is an unreinforced, natural colored thermoplastic material designed for general purpose additive manufacturing applications.

General

Material Status	• Commercial: Active
Availability	• North America
Uses	• Additive Manufacturing (3D Printing)

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.05		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	6100	psi	ASTM D638
Tensile Elongation (Break)	40	%	ASTM D638
Flexural Modulus	375000	psi	ASTM D790
Flexural Strength	10000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	4.0	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	198	°F	ASTM D648
Additional Information	Nominal Value	Unit	Test Method
Recommended Print Bed	Aluminum bed with cement glue or Kapton tape, glass epoxy laminate board, or PEI sheet		
Recommended Print Bed Temperature	194 to 230	°F	

Processing Information

Extrusion	Nominal Value	Unit
Drying Temperature	185	°F
Drying Time	1.0 to 4.0	hr
Cylinder Zone 1 Temp.	475 to 510	°F
Cylinder Zone 2 Temp.	480 to 520	°F
Cylinder Zone 3 Temp.	480 to 520	°F
Cylinder Zone 4 Temp.	480 to 530	°F
Melt Temperature	480 to 530	°F
Die Temperature	490 to 530	°F

Extrusion Notes

If drying for longer than 6 hours, recommend reducing the temperature to 140°F in a dessiccant dryer to avoid degradaton of the material.

Notes

¹ Typical properties: these are not to be construed as specifications.

